

Work Order ID 95593

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Item ID: EA20469-24 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: ROD
 Start Date: 1/15/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 1/17/13 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
EA2046901	1								
100	DOOSAN LATHE	0.00				2	0		DAS 1/13/13
100									
Doosan	Memo	0.00							
Doosan Lathe	1- Turn as per Folio FA								
	Rev: <u>1</u>								
	Rev: <u>NA</u>								
	3-Deburr per dwg								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				2	0		DAS 1/13/13
110									
QC	Memo	0.00							
Quality Control									

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 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00							
140									
QC	Memo	0.00							
Quality Control	100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT								
180	Identify as per dwg & Stock Location: <u>57283</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

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ML5 13-01-16

13.01.16

Picklist Print

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Work Order ID: 95593

Parent Item: EA20469-24

Parent Item Name: ROD

Start Date: 1/15/13

Required Date: 1/17/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-02-21 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NR0.750		Purchased	No			100	f	14.1480	0.166	0.3494737			
4130 steel RD bar .750"													

Location	Loc Qty	Loc Code
MAT031	14.148	
111823	1.648	
123772	12.5	

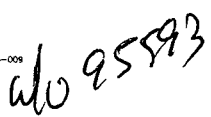
4130 R-375

123724

4 RA

DA 13-1-16

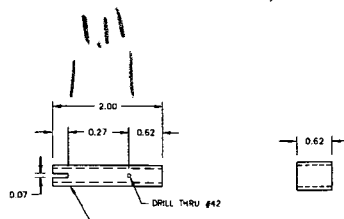
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	INNER PAIR OF ARM GUIDES CHANGED FROM WELDED TO RIVETED	DW	15 AUG 20



SCALE 1:1



SCALE 1:1



(28) ARM GUIDE
SCALE 1:1

1. MELTING OF 4130 STEEL ALLOY TO BE COMPLETED BY GIAN METHOD TO AWS288SC. WELDING ROD SHALL CONFORM TO AWS 64574 OR LATER VERSION.
2. HEAT AND FORM DOOR PLATES (ITEM 26 & ITEM 27) TO SHAPE OF DOOR JAMB. PLOT HOLE LOCATIONS ARE APPROXIMATE. MAINTAIN 20 EDGE DISTANCE.
3. THOROUGHLY DEGREASE, PRIME, AND PAINT ALL PIECES AFTER ASSEMBLY.
4. OUTER PAIR OF ARMS GUIDES (ITEM 28) WELDED TO DOOR PLATES AS SHOWN. INNER PAIR OF ARMS GUIDES LEFT LOOSE UNTIL ASSEMBLY WITH DOOR AND THEN FASTENED TO ARM WITH CR3242-3 RIVETS AFTER ARM ALIGNMENT.

QTY	DASH NO.	DESCRIPTION	PART NO.	MATERIAL	MATERIAL SPEC.	STOCK SIZE
1	29	ARM	E204049-29	4130 STEEL	ML-1-6736	#3/8 O.D. x 0.093 WALL
4	26	ARM GUIDE	E204049-28	4130 STEEL	ML-1-6736	#3/8 O.D. x 0.093 WALL
1	27	DOOR PLATE	E204049-27	MILD STEEL		0.067" SHEET
1	28	DOOR PLATE	E204049-26	MILD STEEL		0.067" SHEET
1	25	ARM SUB-ASSEMBLY	E204049-25			
1	24	ROD	E204049-24	4130 STEEL	ML-1-6736	#3/8 O.D. x 0.093 WALL
1	23	LINK	E204049-23	4130 STEEL	ML-S-1878	0.087" SHEET
2	22	LINK	E204049-22	4130 STEEL	ML-S-1878	0.087" SHEET
1	21	DOOR COVER PANEL	E204049-21			
20	20	FUENT MANUAL SUPPLEMENT 2148, 2148-1	E204050-20			
20	20	FUENT MANUAL SUPPLEMENT 212, 412	E204050-20			
20	20	FUENT MANUAL SUPPLEMENT 200A, 200A-1	E204050-20			
1	20	FUENT MANUAL SUPPLEMENT 20-48	E204050-20			
1	19	EAGLE SERVICE INSTRUCTION	E204049-19			
1	18	DOOR INNER SKIN	E204049-18			
1	17	ANGLE	E204049-17			
1	16	ARM REST ASSEMBLY	E204049-16			
1	15	INSTRUMENT PANEL	E204049-15			
1	14	WINDOW RETAINER	E204049-14			
1	13	INSTRUMENT WINDOW	E204049-13			
1	12	FORWARD ROD	E204049-12			
1	11	ANGLE	E204049-11			
1	10	REARWARD RIS	E204049-10			
1	9	ANGLE	E204049-09			
1	8	PLACARD - INSTRUMENT PANEL	E204049-08			
1	7	ANGLE	E204049-07			
1	6	ALUMINUM STRIP	E204049-06			
1	5	RUBBER STRIP	E204049-05			
4	4	DOOR LATCH ASSEMBLY	E204049-04			
1	3	PLEXIGLASS BUBBLE WINDOW	E204049-03			
1	2	INSTALLATION - DOOR MOUNTED INSTRUMENTS				
1	1	INSTALLATION - BUBBLE WINDOW				

[illegible]